

# Work Order ID 69118

Monday, May 02, 2011 12:24:39 PM



Page 1

Item ID: D350-689-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Dual High Back Seat Assembly

Start Date: 5/2/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/11/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

*mt*

Date:

*11-05-02*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

DSI 9498

A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-689-043 CHG002

*EC* *NAT*

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Assemble as per IIN 350-689

*Q2 11-5-19* *5/11/05/18* *(XV)*

120

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

*SP 11/05/18*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 69118**

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Page 2

Item ID: D350-689-043

Accept

Setup Start

Revision ID:

Stop

Item Name: Dual High Back Seat Assembly

Start Date: 5/2/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 5/11/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



M 115128.

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:20  
350°  
10:50

1 BL 11-5-18.

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 d 11/05/18

150

Large Fab

0.00



Large Fab

Memo

0.00

Large Fab

Assemble as per IIN 350-689

GS 11/05/18 @

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 69118**

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Item ID: D350-689-043

Accept

Setup Start

Revision ID:

Stop

Item Name: Dual High Back Seat Assembly

Start Date: 5/2/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 5/11/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

SB 11/05/18

①

170

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

PP P69118

11/05/18

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/18

11-05-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries

# Picklist Print

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Page 1

Work Order ID: 69118

Parent Item: D350-689-043

Parent Item Name: Dual High Back Seat Assembly







Start Date: 5/2/2011

Required Date: 5/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-12-24 new issue DD verified by:ECI PP Rev:B as per  
DSI 9498 DD 10.02.12 verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-12A  Bolt		Purchased	No			150	Each	113.0000	3	3			
<div> <div>Location</div> <div>ST351</div> <div>114536</div> <div>116786</div> </div> <div> <div>Loc Qty</div> <div>113</div> <div>13</div> <div>100</div> </div> <div> <div>Loc Code</div> <div></div> </div>													
D3016-041  Seat Frame Assembly		Manufactured	No			150	Each	0.0000	2	2			
<div> <div>Location</div> <div>68728X1</div> </div> <div> <div>Loc Qty</div> <div></div> </div> <div> <div>Loc Code</div> <div></div> </div>													
D3017-041  Back Frame Assembly		Manufactured	No			110	Each	0.0000	1	1			
<div> <div>Location</div> <div>69265X1</div> </div> <div> <div>Loc Qty</div> <div></div> </div> <div> <div>Loc Code</div> <div></div> </div>													
D3021-041  Tube Assembly		Manufactured	No			150	Each	0.0000	1	1			
<div> <div>Location</div> <div>69328X1</div> </div> <div> <div>Loc Qty</div> <div></div> </div> <div> <div>Loc Code</div> <div></div> </div>													
D3022-1  Seat Pan		Manufactured	No			150	Each	3.0000	1	1			
<div> <div>Location</div> <div>WA025</div> <div>52352</div> </div> <div> <div>Loc Qty</div> <div>3</div> <div>3</div> </div> <div> <div>Loc Code</div> <div></div> </div>													
D3023-1  Back Panel		Manufactured	No			110	Each	0.0000	1	1			
<div> <div>Location</div> <div>69131</div> </div> <div> <div>Loc Qty</div> <div></div> </div> <div> <div>Loc Code</div> <div></div> </div>													

6

2511/05/18

3

EL 11-5-17

EL 11-5-17

EL 11-5-17

EL 11-5-17

1

EL 11-5-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



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Page 2

Work Order ID: 69118

Parent Item: D350-689-043

Parent Item Name: Dual High Back Seat Assembly

Start Date: 5/2/2011

Required Date: 5/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3024-1

Manufactured No

150 Each

15.0000

3

3



Spacer

Location

Loc Qty

Loc Code

ST030

15

50343

2

68734

13



*5/5/05/18*

D3031-1

Manufactured No

150 Each

1.0000

2

2



Loop

Location

Loc Qty

Loc Code

ST031

1

43395

1



*5/5/05/18*

68621 (2x)

D3808-041

Manufactured No

150 Each

5.0000

2

2



Seat Rail Assembly

Location

Loc Qty

Loc Code

ST262

5

41238

1

44695

4



*5/5/05/18*

D3809-1

Manufactured No

150 Each

12.0000

4

4



Sliding Block

Location

Loc Qty

Loc Code

ST084

12

44696

12



*5/5/05/18*

*4*

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 3

Work Order ID: 69118

Parent Item: D350-689-043

Parent Item Name: Dual High Back Seat Assembly

Start Date: 5/2/2011

Required Date: 5/11/2011

Start Qty: 1.00

Required Qty: 1.00

MS20600-AD4W2 Purchased

No

110

Each

260.0000

40

40



Rivet

Location

Loc Qty

Loc Code

ST321

260

116391

100

116471

4

116805

100

117317

56



*EP 5/10/18*

MS20600-AD4W3 Purchased

No

150

Each

1,191.000

6

6



Cherry Rivets

Location

Loc Qty

Loc Code

ST321

866

111636

366

117505

500

WA018

325

107939

325



*EP 5/10/18*

MS21042L3 Purchased

No

150

Each

2,104.000

17

17



Nut

Location

Loc Qty

Loc Code

ST300

2104

116391

11

116540

527

116549

766

117441

800



*EP 5/10/18*

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Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Work Order ID: 69118

Parent Item: D350-689-043

Parent Item Name: Dual High Back Seat Assembly

Start Date: 5/2/2011

Required Date: 5/11/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L4 Purchased No

150 Each

4,748.000 6



Nut



6  
6  
5/11/05/18

Location

Loc Qty

Loc Code

ST300

4748

116823

1748

117441

3000

6

MS24693-S272 Purchased No

150 Each

65.0000 4



Screw



4  
4  
5/11/05/18

Location

Loc Qty

Loc Code

ST288

65

116391

15

116737

50

4

MS24694-S148 Purchased No

150 Each

46.0000 4



Screw



4  
4  
5/11/05/18

Location

Loc Qty

Loc Code

ST289A

46

108946

2

108960

44

4

MS24694-S3 Purchased No

150 Each

43.0000 8



Screw



8  
8  
5/11/05/18

Location

Loc Qty

Loc Code

ST289

43

108936

31

112794

12

8

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 69118

Parent Item: D350-689-043

Parent Item Name: Dual High Back Seat Assembly

Start Date: 5/2/2011

Required Date: 5/11/2011

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-17 Purchased No

150 Each

46.0000

4

4



Screw



*5/11/05/18*

Location

Loc Qty

Loc Code

ST292

46

11540

46

4

MS27039-1-19 Purchased No

150 Each

102.0000

6

6



Screw



*5/11/05/18*

Location

Loc Qty

Loc Code

ST292

102

100089

2

112794

100

6

MS27039-4-21 Purchased No

150 Each

36.0000

6

6



Screw



*5/11/05/18*

Location

Loc Qty

Loc Code

ST293

36

114055

1

116845

35

6

NAS1149D0332J Purchased No

150 Each

2,779.000

17

17



Washer



*5/11/05/18*

Location

Loc Qty

Loc Code

FP-B

4

117010

4

ST297

2000

117087

2000

ST298

775

117291

775

17

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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# Picklist Print

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Work Order ID: 69118



Parent Item: D350-689-043



Parent Item Name: Dual High Back Seat Assembly

Start Date: 5/2/2011

Required Date: 5/11/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0432J

Purchased

No

150

Each

248.0000

6

6



WASHER



*Handwritten signature and date: 5/11/05/18*

Location

Loc Qty

Loc Code

ST298

248

114718

48

116583

200

*Handwritten number 6*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-689 REV. A  
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-689 REV 0

REF TCCA STC: SH02-33  
REF FAA STC: SR01620NY  
REF EASA STC: EASA.IM.R.S.01453  
REF BRAZILIAN STC: 2005S03-09

## PURPOSE:

TO UPDATE THE PARTS LIST AND THE WEIGHT AND BALANCE TABLE IN IIN-D350-689 REV A AND ICA-D350-689 REV 0.

## CHANGE:

FOR D350-689-011 AT CHANGE 003, D350-689-021 AT CHANGE 002, D350-689-041 AT CHANGE 002 AND D350-689-043 AT CHANGE 002, QTY (6) OF: MS27039-1-19 SCREW; MS21042L3 NUT & AN960JD10L WASHER REPLACED WITH QTY (6) OF: MS27039-4-21 SCREW; MS21042L4 NUT & NAS1149D0432J WASHER RESPECTIVELY. FIGURE 6 (PG 9) OF IIN-D350-689 MODIFIED PER SHT 2 OF THIS SERVICE INSTRUCTION. THE HARDWARE SECTION OF THE PARTS LIST IN SECTION 5 (PG 10) OF IIN-D350-689 REV A & SECTION 25.6 (PG 31) OF ICA-D350-689 REV 0 IS AMENDED AS FOLLOWS:

Qty -011	Qty -013	Qty -021	Qty -023	Qty -041	Qty -043	Part Number	Description
X						D350-689-011	DUAL HIGH BACK SEAT INSTALLATION, LH
1	X					D350-689-013	FLOOR PROVISIONS KIT
		X				D350-689-021	DUAL HIGH BACK SEAT INSTALLATION, LH (REF DSI 9419)
		1	X			D350-689-023	ENERGY ATTENUATING FLOOR PROVISION KIT (REF DSI 9419)
1				X		D350-689-041	DUAL HIGH BACK SEAT ASSEMBLY
		1			X	D350-689-043	DUAL HIGH BACK SEAT ASSEMBLY (REF DSI 9419)
	6			17	17	NAS1149D0332J	WASHER (OR AN960JD10L)
			9			NAS1149D0363J	WASHER (OR AN960JD10)
				6	6	NAS1149D0432J	WASHER (OR AN960JD416)
				3	3	AN3-12A	BOLT
16						MS20426AD3-6	RIVET
			14			MS20426AD4-5	RIVET
17						MS20426AD4-6	RIVET
18			34			MS20470AD4-5	RIVET
2			18			MS20470AD4-6	RIVET
30			32			MS20470AD5-6	RIVET
				40	40	MS20600AD4W2	RIVET
				6	6	MS20600AD4W3	RIVET (REF DSI 9349)
8						MS21059L3	NUTPLATE
6						MS27039-1-10	SCREW
				4	4	MS27039-1-17	SCREW
				6	6	MS27039-1-19	SCREW
				6	6	MS27039-4-21	SCREW
				4	4	MS24693-S272	SCREW
2						MS24693-S273	SCREW
				8		MS24694-S3	SCREW
			9			MS24694-S50	SCREW
				4		MS24694-S148	SCREW
			9	17	17	MS21042L3	NUT (OR MS21042-3)
				6	6	MS21042L4	NUT (OR MS21042-4)

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED  
BY: *[Signature]*  
D. SHEPHERD (DE # 02)

DATE: 10.01.21  
CERT. NO.: SH02-33  
ISSUE NO.: 1

A	NEW ISSUE.	JPH	10.01.21
REV.	DESCRIPTION	BY	DATE
DESIGN	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO. DSI 9498 REV. A SHEET 1 OF 2  TITLE SEAT REINF; IIN & ICA UPDATE SCALE NTS		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.01.21		
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

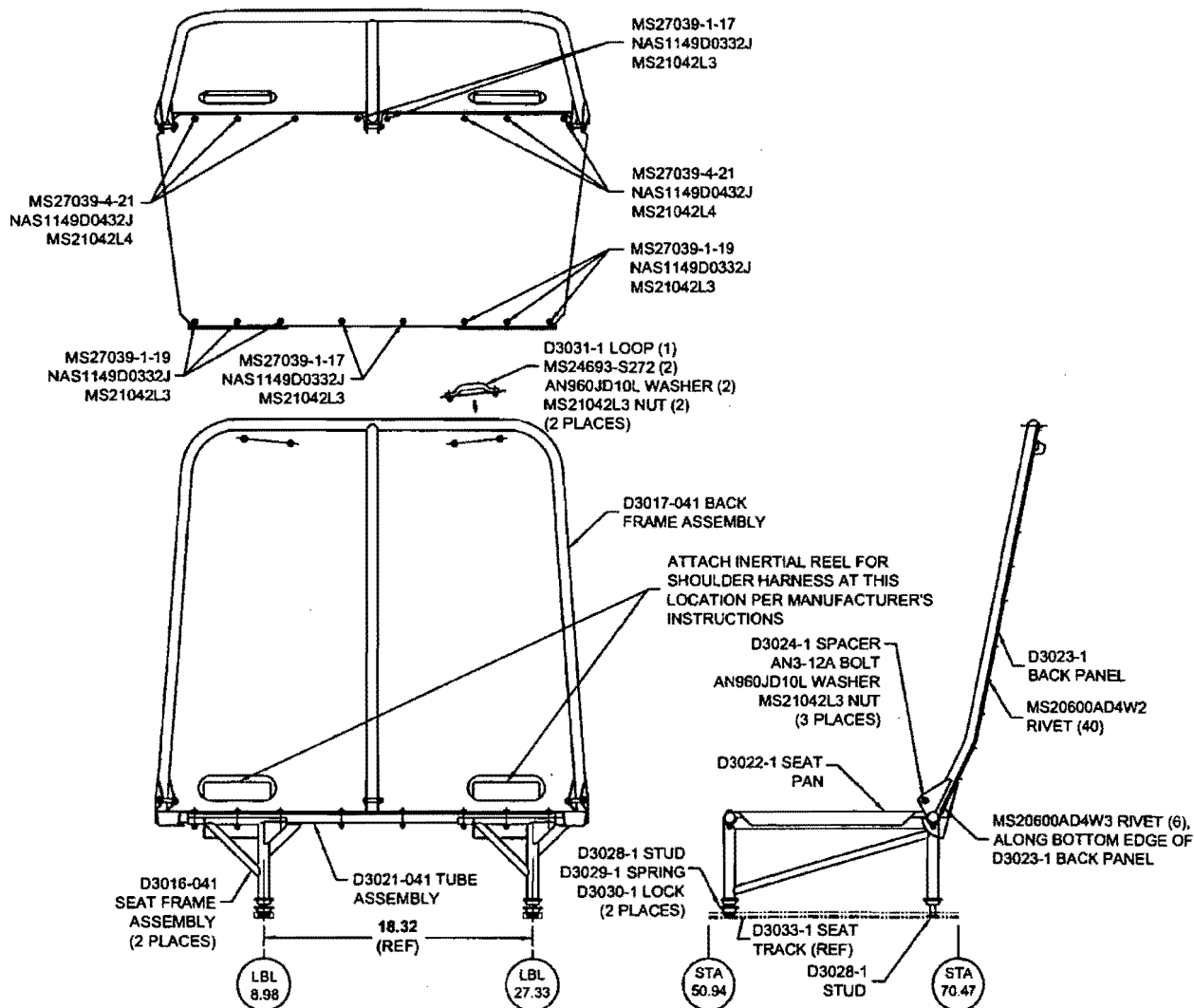
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**CHANGE:**

THE FOLLOWING WEIGHT AND BALANCE INFORMATION IS FOR THE D350-689-011 DUAL HIGH BACK SEAT AT CHANGE 003 (OR LATER) AND THE D350-689-021 DUAL HIGH BACK SEAT AT CHANGE 002 (OR LATER).

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-689-011 Dual High Back Seat Installation	27.6 lb 12.5 kg	-18.2 in -0.46 m	-502 in-lb -5.8 m-k-g	60.7 in 1.54 m	1675 in-lb 19.3 m-k-g
D350-689-021 Dual High Back Seat Installation, LH Fwd Position	29.2 lb 13.2 kg	-18.2 in -0.46 m	-531 in-lb -6.1 m-k-g	60.7 in 1.54 m	1772 in-lb 20.3 m-k-g
D350-689-021 Dual High Back Seat Installation, LH Aft Position	29.2 lb 13.2 kg	-18.2 in -0.46 m	-531 in-lb -6.1 m-k-g	64.7 in 1.64 m	1889 in-lb 21.6 m-k-g

**REF FIGURE 6 (IIN-350-689)**

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

**APPROVED**

BY: *[Signature]*  
D. SHEPHERD (DE # 02)

DATE: 10.01.21  
CERT. NO.: SH02-33  
ISSUE NO.: 1

DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9498	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SEAT REINF; IIN & ICA UPDATE	NTS
DATE	10.01.21	COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries